

Work Order ID 52437

September 23, 2009 2:59:24 PM



Page 1

Item ID: PB67-43001-57

DG

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Stabilizer Arm

Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-09-23 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	Rev B1

100	Large Fab	0.00							
	Memo	0.00							
	1-Weld assembly as per dwg PB67-43001								

lpl 09-09-28

(2)

110	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
	Quality Control								

2

2009-09-29

120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
	Quality Control								

DD

09.09.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52437

September 23, 2009 2:59:24 PM



Page 2

Item ID: PB67-43001-57

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Stabilizer Arm

Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1- line drill -107 and -109 using existing pilot hole of -107 as per dwg 2- install spring pin

Cpl 09 09 28

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

2/8 09/10/02

(42)

150



Powdercoat

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME: *8:30am* OVEN TEMPERATURE:
FINISH TIME: *9:00am* *320°F*

2/8 09/10/02

(42) 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52437

September 23, 2009 2:59:24 PM



Page 3

Item ID: PB67-43001-57

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Stabilizer Arm

Start Date: 09/25/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

*BLO-10-2**(2)*

170

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Packaging

9/10/2 @ SP

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*09/10/05**MF 09-10-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 2:59:24 PM

Page 1

Work Order ID: 52437

Parent Item: PB67-43001-57RevB1

Parent Item Name: Stabilizer Arm



Comments:

Start Date: 09/25/2009

Required Date: 10/02/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
240-107  SPRING SLOTTED PIN		Purchased	No			100	Each	296.0000	4.0000			
											SAD 09-09-28	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

296

109274

91

111088

205

PB67-43001-107RevB1

Manufactured No



Tube Arm

130

Each

2.0000

2.0000



4

SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

41474

2

PB67-43001-109RevB1

Manufactured No



Male Eye

130

Each

5.0000

2.0000



2

SAD 09-09-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

41475

5

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 2:59:24 PM

Page 2

Work Order ID: 52437

Parent Item: PB67-43001-57RevB1

Parent Item Name: Stabilizer Arm


Start Date: 09/25/2009

Required Date: 10/02/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ PB67-43001-111RevB1  Tube End Plate		Manufactured	No			100	Each	7.0000	2.0000			

SAP 09-09-08

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
41476	7	

2

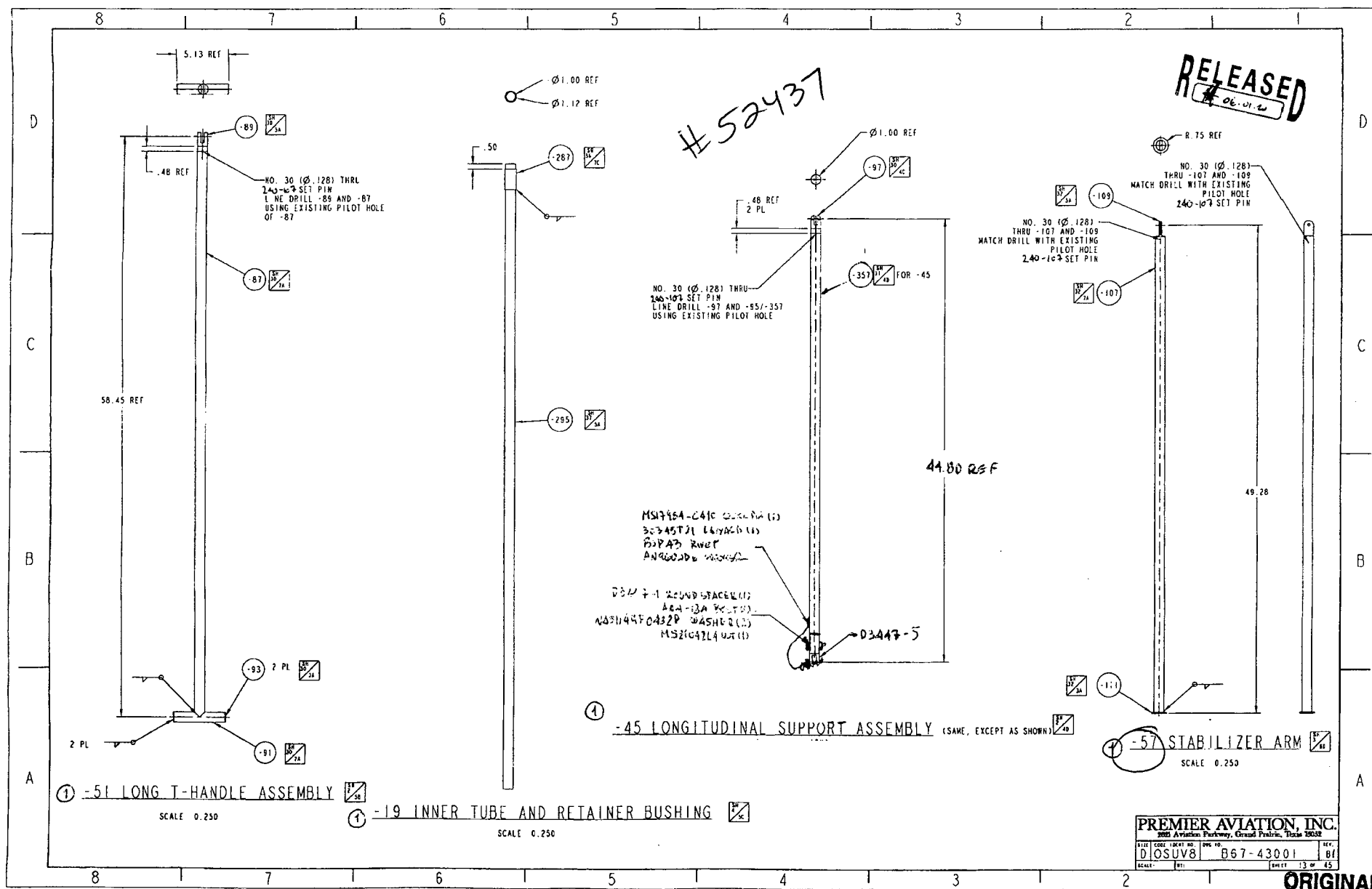
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries